

Date: Tuesday, 07/04/2009 3:22:16 PM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LONGITUDINAL SUPPORT ASSEMBLY
 Job Number : 47057
 Estimate Number : 13524
 P.O. Number : Part Number : PB674300145
 This Issue : 07/04/2009 S.O. No. : Drawing Number : B6743001 P.13
 Prsht Rev. : NC Project Number : N/A
 First Issue : 07/04/2009 Type : SMALL /MED FAB Drawing Revision : B1
 Previous Run : 45028 Material :
 Written By : Due Date : 20/04/2009 Qty: 1 Um: Each
 Checked & Approved By : MF 09-04-08.
 Comment : Est Rev:A 08-07-25 new issue DD verified by:ec

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	240107	SPRING SLOTTED PIN
2.0	PB674300197	Clevis
3.0	PB6743001357	Tube Arm
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
5.0	QC5	INSPECT WORK TO CURRENT STEP

✓

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SPRING SLOTTED PIN

batch: M11088 = 1x.

sp 09.04.13

✓

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Clevis

batch: B418109 = 1x

sp 09.04.13

✓

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tube Arm

batch: B41508 = 1x

sp 09.04.13

4.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1- line drill -97 and -357 using existing pilot hole of -357 as per dwg

2- install spring pin

sp 09.04.14 (1x)

5.0

QC5

INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

sp 09.04.14 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 3:22:16 PM
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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



11814U

Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

2:20pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

2:50pm

SH

09-04-16

XD

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-04-16

D

8.0

D34475

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Clevis

batch: B41221

Pl 09-04-20

9.0

D34471

Round Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Round Spacer

batch: B41458

Pl 09-04-20

10.0

AN413A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

batch: M110731

Pl 09-04-20

11.0

NAS1149F0432P

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M18057

Pl 09-04-20

12.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Nut

batch: M109282

Pl 09-04-20

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Job Number: 47057

Part Number: PB674300145

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	MS17984C410	QUICK PIN REPLACEMENT
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

QUICK PIN REPLACEMENT

batch: m111119

pl09.04.20

14.0	30345T21	LANYARD
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

LANYARD

batch: m17828

pl09.04.20

15.0	BSP43	RIVET
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

RIVET

batch: m109119

pl09.04.20

16.0	AN960JD6	Washer
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Washer

batch: m6085

pl09.04.20

17.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: Assemble parts as per dwg PB67-43001

pl09.04.20

(X1)

18.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/04/20 (X0)

19.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9/4/20

(X4)

SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: PB674300145

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/22 *[Signature]*

Job Completion



MF 09-04-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

